

Date: Wednesday, 18/06/2008 11:20:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CABIN DOOR ROLLER KIT, LH		
Job Number	: 39916					
Estimate Number	: 10276					
P.O. Number	:			Part Number	: D412698011	
This Issue	: 18/06/2008		S.O. No. :	Drawing Number	: IIN D412-698 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: D	
Previous Run	: 39025			Material	:	
Written By	:			Due Date	: 07/07/2008	
Checked & Approved By	: JUL 08. (e. 18)			Qty:	4 Um: Each	
Comment	: Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
2.0	PACKAGING 1	PACKAGING RESOURCE #1
3.0	D3121141	Bracket Assembly
4.0	D3121143	Bracket Assembly
5.0	D3137043	Bracket Assembly

Comment: DOCUMENT CONTROL
Photocopy bluefile and create labels per PPP D412-698-011 CHG003 *S 08/08/06*

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
3 D3121-141 Bracket Assembly *39921*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D3121-143 Bracket Assembly *39922*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D3121-143 Bracket Assembly *29275* *R 08/06/06 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 11:20:49 AM

User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, LH

Job Number: 39916

Part Number: D412698011

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1	D3137-043	Bracket Assembly								
6.0	D3183043	Bracket Assembly								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick: Packing Kit</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D3183-043</td> <td>Bracket Assembly</td> <td>39862</td> </tr> </table>			Qty	Part Number	Description	Batch	1	D3183-043	Bracket Assembly	39862
Qty	Part Number	Description	Batch							
1	D3183-043	Bracket Assembly	39862							
7.0	D31991	Bracket								
<p>Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)</p> <p>Pick: Packing Kit</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>9</td> <td>D3199-1</td> <td>Bracket</td> <td>39843</td> </tr> </table>			Qty	Part Number	Description	Batch	9	D3199-1	Bracket	39843
Qty	Part Number	Description	Batch							
9	D3199-1	Bracket	39843							
8.0	D32021	Cover								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick: Packing Kit</p> <table> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D3202-1</td> <td>Cover</td> <td>39925</td> </tr> </table>			Qty	Part Number	Description	Batch	1	D3202-1	Cover	39925
Qty	Part Number	Description	Batch							
1	D3202-1	Cover	39925							
9.0	QC4	INSPECT 100% KITS FOR COMPLETENESS								
<p>Comment: INSPECT 100% KITS FOR COMPLETENESS</p>										
10.0	PACKAGING 1	PACKAGING RESOURCE #1								
<p>Comment: PACKAGING RESOURCE #1</p> <p>Identify and pack for shipping as per PPP D412-698-011</p> <p>Location: B</p>										
11.0	QC21	FINAL INSPECTION/W/O RELEASE								
<p>Comment: FINAL INSPECTION/W/O RELEASE</p>										
Job Completion										
<p style="text-align: right;">MF 08-08-07</p>										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9				9		D3199-1	BRACKET
1	1				1		D3202-1	COVER
					4		D3203-1	HANDLE
					1		D3220-041	DOUBLER
					1		D3220-042	DOUBLER
					2		D3220-3	DOUBLER
					2		D3200-1	DOOR POST BLOCK
					2		D3200-3	DOOR WEDGE
					2		D3201-1	DOUBLER
					1		D3201-3	ANGLE
					1		D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
					12		AN960JD10L	WASHER
					8		AN960JD416L	WASHER
					12		MS21042L3	NUT (OR MS21042-3)
					8		MS21042L4	NUT (OR MS21042-4)
					16		MS24694-S98	SCREW
						1	MS24694-S101	SCREW
						12	MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

• COPYRIGHT © 2003 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

WORK ORDER

N/A 3916

Revision: D
Date: 07.07.03

Date: Wednesday, 18/06/2008 11:20:49 AM
 User: Julie Lecocq

Process Sheet

DJ

Customer:	CU-DAR001 Dart Helicopters Services		Drawing Name	CABIN DOOR ROLLER KIT, LH		
Job Number	39916					
Estimate Number	10276					
P.O. Number	:			Part Number	D412698011	
This Issue	18/06/2008		S.O. No. :	Drawing Number	IIN D412-698 REVD	
Prsht Rev.	NC			Project Number	N/A	
First Issue	/ /		Type : MACHINED PARTS	Drawing Revision	D	
Previous Run	39025			Material	:	
Written By	:			Due Date	07/07/2008	
Checked & Approved By	<u>JUL 08.6.18</u>			Qty:	4 Um: Each	
Comment	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD					

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL <u>JUL 08.6.18</u>
2.0	PACKAGING 1	PACKAGING RESOURCE #1
3.0	D3121141	Bracket Assembly
4.0	D3121143	Bracket Assembly
5.0	D3137043	Bracket Assembly

Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
3 D3121-141	Bracket Assembly	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3121-143	Bracket Assembly	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number	Description	Batch
1 D3137043	Bracket Assembly	